

Date: Monday, 1/8/2007 10:53:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 30161	
Estimate Number : 11968	
P.O. Number : N/A	Part Number : D2061
This Issue : 1/8/2007 S.O. No. : N/A	Drawing Number : D2061 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 28138	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 1/30/2007 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.01.08	
Comment : Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 2829

Make per Dwg D2061

Possible Supplier: Sieg's Manufacturing

Material release note required

CZ 07/01/09

(50)

2.0

D2061P

Aspirator

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

ASPIRATOR BODY

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

R 07/01/17

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

07/01/19

(50)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr and clean to remove was residue

SB 07/01/22

(50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:53:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30161

Part Number: D2061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/01/24 (50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57213

12/07/01/24 (50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

12/07/01/24

Job Completion



12/07/01/24

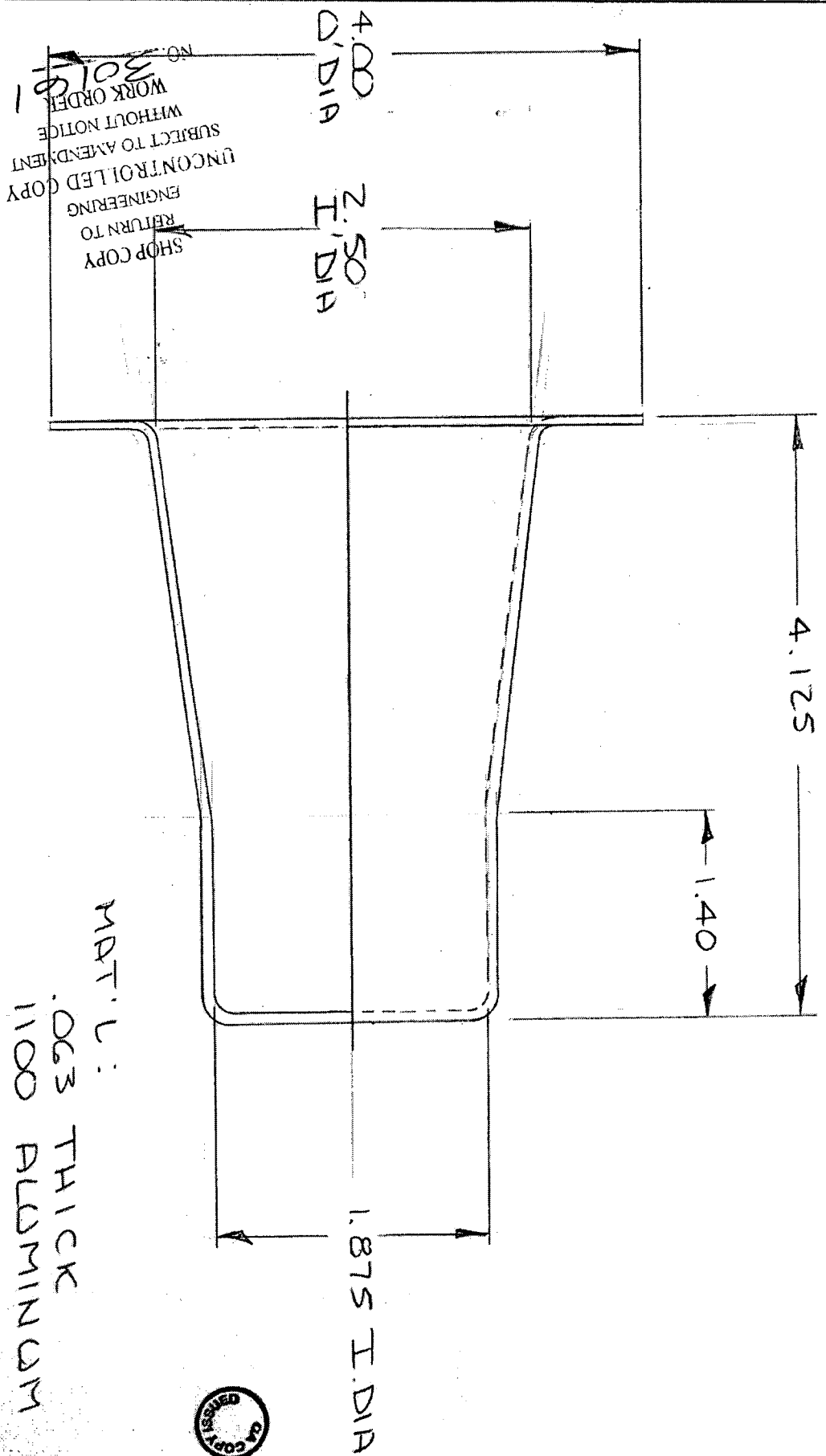
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MAT'L:
 .063 THICK
 1100 ALUMINUM

REVISION		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC. / VENDOR	
DRAWN		CONTRACT NO.		DATE		TITLE		DART AERO ACCESSORIES INC.		CANADA	
APPROVED		DRAWN		DATE		DART		VANCOUVER			
DESCRIPTION		DESIGN		1991		ASPIRATOR BODY					
OR CHANGE		CHECKED				CODE		YSD 2061		REV.	
		CLIENT				SCALE		1:1		SHT. 1 OF 1	

REPORT ALL DISCREPANCIES - DO NOT SCALE

1. DIMENSIONS ARE IN INCHES
 2. SURFACE FINISHES: 100
 3. MATERIAL: 1100 ALUMINUM
 4. TOLERANCES: .015 MAX.
 5. TOLERANCES: .015 MAX.

1. TOLERANCES - .015 MAX.
 2. ANGLES: 90° & 45°
 3. SURFACE FINISHES: 100
 4. SURFACE FINISHES: 100
 5. SURFACE FINISHES: 100

YSD 2061



sm

Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

07/01/19

DATE: Jan 16/07

CUSTOMER: Dart Aerospace PO# 2829

INVOICE #: 30910 SUPPLIER #:

DESCRIPTION OF INSPECTION:

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D2060P	50	.063 1100	✓	✓	JS
D2061P	50	.063 1100	✓	✓	JS

NOTES OF INSPECTION: Good.

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO	COPPER & BRASS SALES INC 22355 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034	SHIP TO	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212	CERT NO 0000598687
	DATE 10/26/2004			
				SKID NO 322296
				SKID WGT 9,760
				PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	0.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten:
Haw
Henry @ SHS
C/O
Sorel
CTR

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF READY, LAB SUPERVISOR

16048320635

5 legs

3-24-05 3:56PM Copper & Brass Sales